

Work Order ID 135354

Thursday, August 13, 2015 10:38:55 AM

135354

Page 1

Item ID: D5124-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwd Support

Start Date: 8/24/2015 Start Qty: 8.00

8

Cust Item ID:

Required Date: 8/24/2015 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: MUS Date: AUG 13 2015

Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5124	B								

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FB340

Folio Rev: AADwg Rev: B

Deburr

7 1
DAS 14 9-89 P80
JFC 2015-08-31

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

7 1
JFC 2015-08-31

DQA:

Date: 15/09/22



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 15/09/08

Work Order update only ☐

Work Order: 135354	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS			
Part No. D5124-1		Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. 15-5312		Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
		Large Fab ☐	Composite ☐	Supplier ☐	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	2015-08-31	100	1	dimension .23 $\pm$ 0.03 is .37 RC. instruction in folio is not clear	15/08/31 a2042.	Scrap & destroy. added. ED that note in folio	JFe 2015-08-31 15/08/31 15.08.31	DAS 08 9-89	PD 1508-31
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General
☐ Bending	☒ Folio/Program
☐ Centre Not Concentric	☐ Grain
☐ Cracks	☐ Hardware
☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified
☐ Cuffs	☐ Instructions Incomplete/Unclear
☐ Crushing	☐ Misaligned/off center
☐ Heat Treat	☐ Mislabeled
☐ Inspection Strip in Tube	☐ Misread
☐ Marks/Chatter	☐ Off-set
☐ Turning Sequence	☐ Out of Calibration
☐ Wave/Twist in Tube	☐ Out of Sequence
☐ Bend	☐ Outside Dimensions
☐ BOM/Route	☐ Over/Under tolerance
☐ Broken/Damage/Defect	☐ Part Incorrect
☐ Burrs	☐ Part Lost/Missing
☐ Contamination	☐ Part Moved
☐ Countersink	☐ Positioned Wrong
☐ Cut Too Short	☐ Power Loss/Surge
☐ Drawing	☐ Pressure/Forced
☐ Drill Holes	☐ Set-up
☐ Finish	☐ Temperature/Cure
☐ Fit/Function	☐ Weld
	☐ Wrong Stock Pulled
	☐ Other

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Thursday, August 13, 2015 10:38:55 AM

135354

Page 2

Item ID: D5124-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fwd Support
Start Date: 8/24/2015 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 8/24/2015 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location: <u>LG055</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging	LOCATION : LG055								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

20150903

Thursday, August 13, 2015 10:38:59 AM

Page 1

135354

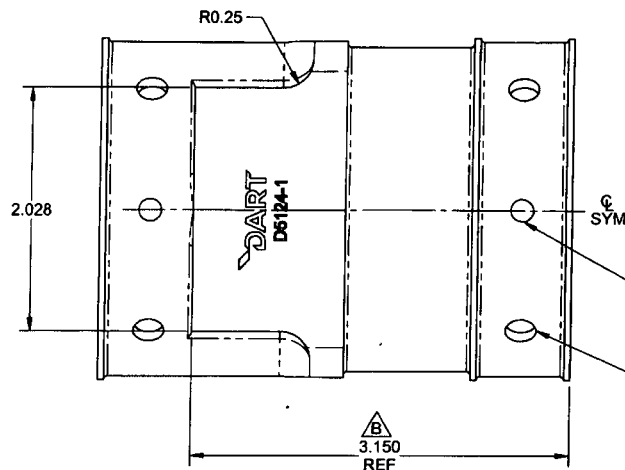
D5124-1

Required Qty: 8.00

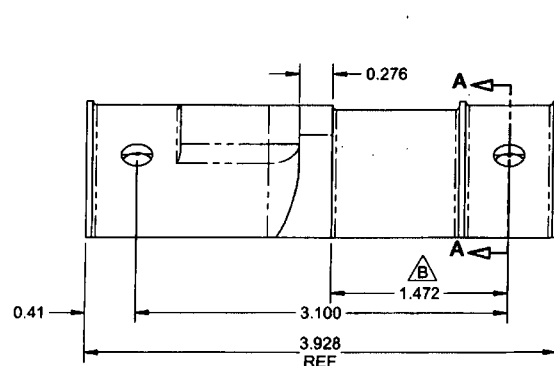
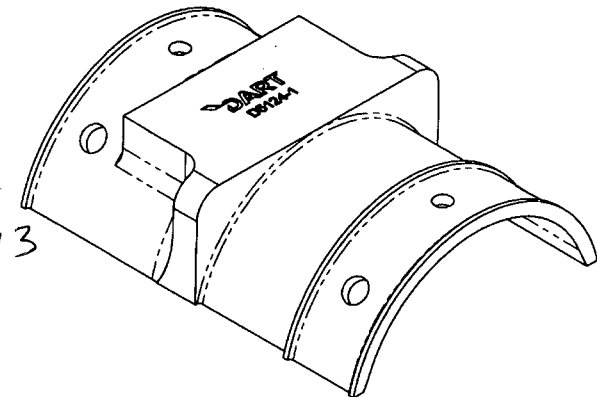
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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4

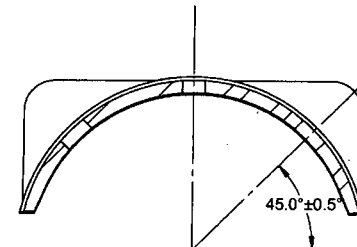
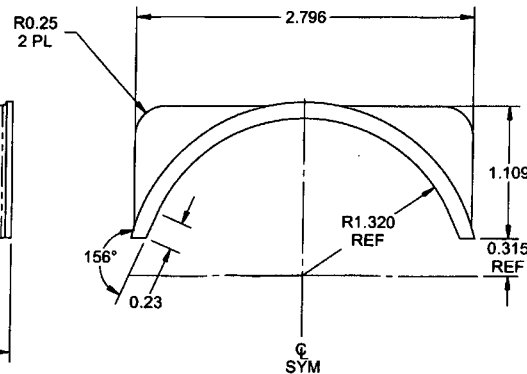
JFL 2015-09-03



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO APPROVAL
WITHOUT NOTICE
WORK ORDER
NO. 135354
ML
1508-13



D5124-1 FWD SUPPORT



SECTION A-A RELEASED

2014 NOV 18

NOTES:

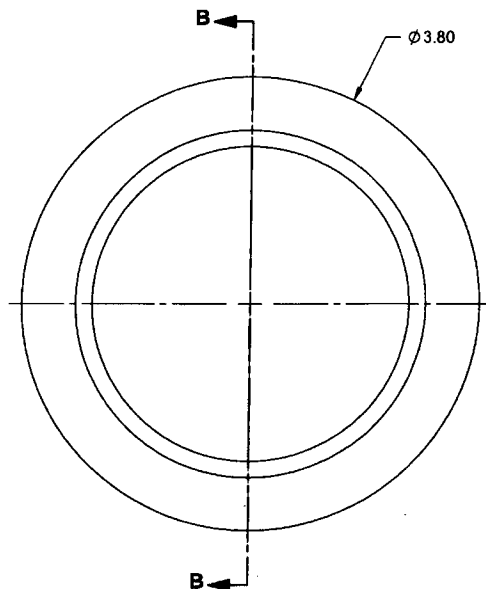
- 1) MATERIAL: MAKE FROM D5124-1TRN
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART LOGO AND P/N "D5124-1" IN AREA SHOWN
USING 0.125 HIGH X 0.010-0.020 DEEP LETTERING PER DART QSI 044 6.3,
IDENTIFY WITH DART B/N PER DART QSI 044 6.1

7) WEIGHT: 0.53 lbs

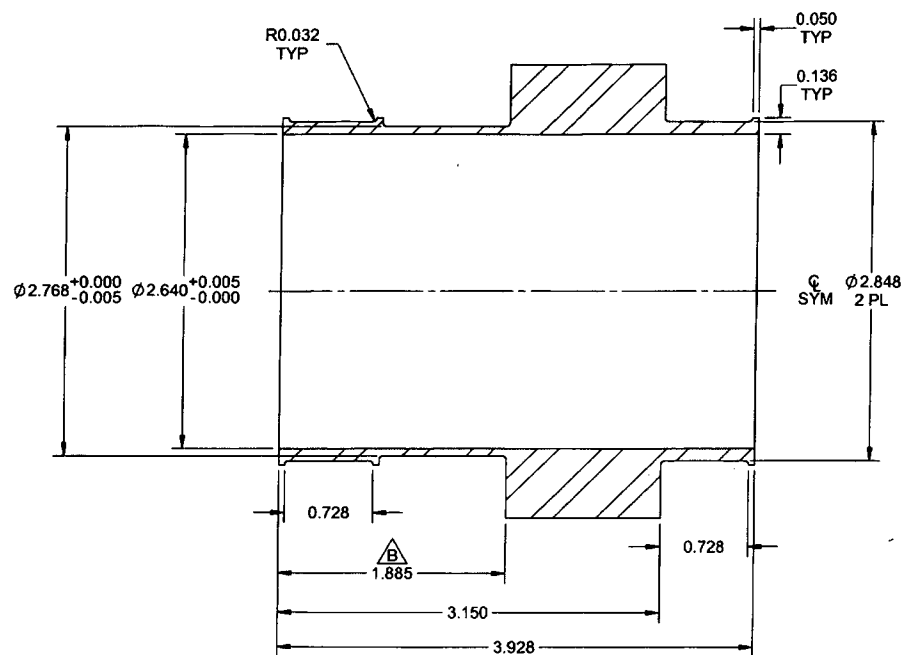
8) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D5124-1-REVB.SLDPRT"

B	DIMENSIONAL CHANGES RESULTING FROM FIRST TEST FIT. SEE REV A FOR DETAILS	AP	14.10.28
A	NEW ISSUE	AP	14.08.07
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D5124 REV. B SHEET 1 OF 2 TITLE FWD SUPPORT SCALE NTS COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DRAWN	AP		
CHECKED	CP		
MFG. APPR.	RQ		
APPROVED	MP		
DE APPR.	DS	DATE 14.10.28	

APPROVED



D5124-1TRN FWD SUPPORT



SECTION B-B

RELEASED

2014 NOV 18

NOTES:

- 1) MATERIAL: 17-4PH/S17400/TYPE 630 ROUND BAR PER AMS 5643 / ASTM A564, REF DART SPEC. M17-4-R H900 OR H925 CONDITION, MIN UTS = 170 KSI (38HRc)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.74 lbs

APPROVED

DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	CP	DRAWING NO.	REV. B
MFG. APPR.	RQ	D5124	SHEET 2 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	FWD SUPPORT	NTS
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